



MAC STAIN E103L

■ **Description & Applications:**

Stainless steel electrode designed for joining stainless steels to Mild or Low Alloy Steel. Designed with low carbon levels to help eliminate carbide precipitation in high temperatures. Flux coating is fast freezing for vertical down welding and slag is self peeling for easy removal.

■ **Related Specification:**

AWS E309L-15

■ **Typical All Weld Metal Chemical Analysis %:**

C	Mn	S	Mo	P	Cr	Ni	Si	Cu
0.03	0.8	0.01	0.04	0.03	23.7	13.7	0.80	0.07

■ **Typical All Weld Metal Mechanical Properties:**

As Welded

Ultimate Tensile Strength	640 N/mm ²
Elongation	38%
Yield Strength	490 N/mm ²

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
60-70	90-100	110-140	140-180

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 250°C before use.